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D5046-7

Job Sheet 185328



Part No: D5046-7

Job Qty: 2 ea **2 ca**

DAS
21
9-89

Part Name: Co-Pilot Collective Head



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/25/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B SHEETS 4,11,12 IPP REV. A NEW ISSUE JFS 14/04/14 VERIFIED BY: DD IPP REV. B MAT'L SIZE HAS CHANGED AS PER REV.B JFS 15/09/23 VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					Hrs	Hrs			
90	Start up Operation	2 Ea		11/9/18	0.00	0.00	Start Up Machining-3		K1 2018-11-19
100	Bandsaw	2 pcs		11/9/18	0.00	0.01	Bandsaw1		K1 2018-11-19
110	CNC Vertical Machining	2 pcs		11/9/18	0.00	7.85	HAAS1-5		K1 2018-11-19
120	QC	2 pcs		11/9/18	0.00	0.00	QC2 Machining-3		K1 2018-11-19
130	Mill Conv	2 pcs		11/9/18	0.00	0.27	Mill Conv 1		
140	QC	2 pcs		11/9/18	0.00	0.00	QC2 Machining-3		
150	QC	2 pcs		11/9/18	0.00	0.00	QC8 Machining-3		K1 11/11/20
160	Packaging	2 pcs		11/9/18	0.00	0.00	Packaging3-2		
170	QC21-SA	2 Ea		11/9/18	0.00	0.00	QC21		DAS 21 NOV 21 2018

Part Op 100 - CUT BLANK AT 5.500"

Descriptions: 110 - MACHINE AS PER DWG & FOLIO FB296/ D5046-7 FOLIO REV: _____ DWG REV: _____ ***DO NOT

BUFF OR POLISH PART*** DEBURR

130 - DRILL REMAINING 2 HOLES AS PER DWG. DWG REV: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B06.000X02.000 2x m133536	Aluminum Bar 6.00 X 2.00	.9180 ft (.459 ea)	90-Start up Operation	2x FM133536

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B06.000X02.000	1	0	0

Part Specifications

Specifications could not be found.

GAVE changed
to order

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition			Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER :									

DART AEROSPACE LTD		Work Order:	185328
Description: Co-Pilot collective Head		Part Number:	D5046-7
Inspection Dwg:	Rev: B	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.150 X 0.600	+0.005/-0.001 x ±0.010	0.150 X 0.602	✓		Kt-05	verm
0.350	±0.010	0.352	✓		" "	" "
3.350	±0.010	3.350	✓		H-G	31006
0.300	±0.010	0.300	✓		" "	" "
2.808	±0.005	2.808	✓		" "	" "
1.892	±0.005	1.892	✓		" "	" "
1.214	±0.005	1.214	✓		" "	" "
2.136	±0.005	2.136	✓		" "	" "
0.25	±0.030	0.250	✓		Kt-01	micrometre.
R0.13	±0.030	0.130	✓		—	R-G
1.66	±0.030	1.662	✓		Kt-05	verm.
0.830	±0.010	0.830	✓		" "	" "
0.375	±0.005	0.375	✓		H-G	31006
Ø0.136	+0.005/-0.001	0.136	✓		Kt-05	verm
Ø0.484	+0.005/-0.001	0.484	✓		" "	" "
1.450	±0.010	1.448	✓		" "	" "
0.830	±0.010	0.830	✓		Kt-05	verm.
Ø0.160	+0.005/-0.001	0.160	✓		" "	" "
Ø0.500	+0.006/-0.001	0.502	✓		" "	" "
Ø0.860 X 0.150 DP	+0.010/-0.001	0.862 X 0.150	✓		" "	" "
0.375	±0.005	0.375	✓		H-G	31006
2.460	±0.010	2.460	✓		Kt-05	verm.
0.254	+0.005/-0.000	0.256	✓		" "	" "
0.200	±0.030	0.200	✓		" "	" "
0.50	±0.030	0.500	✓		" "	" "
5.30	±0.030	5.300	✓		" "	" "
4.00	±0.030	4.000	✓		" "	" "
1.660	±0.010	1.660	✓		" "	" "
Ø0.625	+0.005/-0.000	0.625	✓		" "	" "
Ø0.502	+0.010/-0.001	0.504	✓		" "	" "
0.830	±0.030	0.830	✓		" "	" "

Measured by: KJ	Checked by:	QC Inspector:
Date: 2018-11-19	Date:	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



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Container No: S129251



Part: D5046-7

Job No: 185328

Serial No/Batch: S129251

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/19/18

232
242
252